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Table 1

Estimated Production of Bison and Bear Aircraft at Various Airframe Plants
on the Utilization of Two 46-hour Shifts per Week

	BISON				BEAR			Total BISON and BEAR
	Plant No. 23	Plant No. 22	Plant No. 1	Total	Plant No. 18	Plant No. 1	Total	
Estimate #1 a/								
Mid-1960	240			240	340		340	580
Mid-1962	360			360	560		560	920
Estimate #2 b/								
Mid-1960	340			340	530		530	870
Mid-1962	530			530	790		790	1,320
Estimate #3 b/								
Mid-1960	340	100		440	530	90	620	1,060
Mid-1962	530	380		910	790	310	1,100	2,010
Estimate #4 b/								
Mid-1960	340	100	60	500	530		530	1,030
Mid-1962	530	380	220	1,130	790		790	1,920

Assumptions

1. Acceleration of production begun 1 July 1957 at Plants No 23 and No. 18.
2. First direct manhours on heavy bomber production occurred 1 July 1957 at Plants No. 1 and No. 22.

Footnotes

- a. Utilization of four final assembly positions at Plant No 23 and two-thirds of the factory area at Plant No. 18, the remaining area at Plant No. 18 being used for production of TU-114 aircraft and the overhaul of Bull aircraft.
- b. Maximum utilization of plant area for production of heavy bombers.

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Table 2

Soviet Capability for Production of Bison Aircraft

Two 46-hour Shifts per Week
Acceleration Beginning 1 July 1957

	<u>Units</u>					
	<u>Plant No. 23</u>	<u>Plant No. 22</u>	<u>Plant No. 1</u>	<u>Plant No. 18</u>	<u>Plant No. 39</u>	<u>Plant No. 64</u>
Mid-1960	340	100	60	100	100	100
Mid-1962	530	380	220	350	350	90

S-E-C-R-E-T

S-E-C-R-E-T

Table 3

Soviet Capability for Production of Bear Aircraft

Two 46-hour Shifts per Week
Acceleration Beginning 1 July 1957

	<u>Units</u>				
	<u>Plant No. 18</u>	<u>Plant No. 1</u>	<u>Plant No. 22</u>	<u>Plant No. 39</u>	<u>Plant No. 64</u>
Mid-1960	530	90	140	130	30
Mid-1962	790	310	500	470	100

S-E-C-R-E-T

S-E-C-R-E-T

Table 4

Production of Bison at Plant No. 23

Two 46-hour Shifts per Week
 Four Final Assembly Positions
 Acceleration Beginning 1 July 1957

			Units		
Month	Monthly Production	Cumulative Production	Month	Monthly Production	Cumulative Production
Jun 1957	3	65	Jan 1960	5	211
Jul	3	68	Feb	5	216
Aug	4	72	Mar	5	221
Sep	4	76	Apr	5	226
Oct	4	80	May	5	231
Nov	4	84	Jun	5	236
Dec	4	88	Jul	5	241
			Aug	5	246
Jan 1958	4	92	Sep	5	251
Feb	4	96	Oct	5	256
Mar	5	101	Nov	5	261
Apr	5	106	Dec	5	266
May	5	111			
Jun	5	116	Jan 1961	5	271
Jul	5	121	Feb	5	276
Aug	5	126	Mar	5	281
Sep	5	131	Apr	5	286
Oct	5	136	May	5	291
Nov	5	141	Jun	5	296
Dec	5	146	Jul	5	301
			Aug	5	306
Jan 1959	5	151	Sep	5	311
Feb	5	156	Oct	5	316
Mar	5	161	Nov	5	321
Apr	5	166	Dec	5	326
May	5	171			
Jun	5	176	Jan 1962	5	331
Jul	5	181	Feb	5	336
Aug	5	186	Mar	5	341
Sep	5	191	Apr	5	346
Oct	5	196	May	5	351
Nov	5	201	Jun	5	356
Dec	5	206			

S-E-C-R-E-T

S-E-C-R-E-T

Table 5

Production of Bear at Plant No. 18

Two 46-hour Shifts per Week
 Using Two-thirds of Plant Area
 Acceleration Beginning 1 July 1957

			Units		
Month	Monthly Production	Cumulative Production	Month	Monthly Production	Cumulative Production
Jun 1957	2	51	Jan 1960	9	297
Jul	5	56	Feb	9	306
Aug	6	62	Mar	9	315
Sep	6	68	Apr	9	324
Oct	6	74	May	9	333
Nov	6	80	Jun	9	342
Dec	7	87	Jul	9	351
			Aug	9	360
Jan 1958	7	94	Sep	9	369
Feb	7	101	Oct	9	378
Mar	7	108	Nov	9	387
Apr	7	115	Dec	9	396
May	8	123			
Jun	8	131	Jan 1961	9	405
Jul	8	139	Feb	9	414
Aug	8	147	Mar	9	423
Sep	8	155	Apr	9	432
Oct	8	163	May	9	441
Nov	8	171	Jun	9	450
Dec	9	180	Jul	9	459
			Aug	9	468
Jan 1959	9	189	Sep	9	477
Feb	9	198	Oct	9	486
Mar	9	207	Nov	9	495
Apr	9	216	Dec	9	504
May	9	225			
Jun	9	234	Jan 1962	9	513
Jul	9	243	Feb	9	522
Aug	9	252	Mar	9	531
Sep	9	261	Apr	9	540
Oct	9	270	May	9	549
Nov	9	279	Jun	9	558
Dec	9	288			

S-E-C-R-E-T

S-E-C-R-E-T

Table 6

Production of Bison at Plant No. 23

Two 46-hour Shifts per Week
 6 Final Assembly Positions
 Acceleration Beginning 1 July 1957

			Units		
Month	Monthly Production	Cumulative Production	Month	Monthly Production	Cumulative Production
Jun 1957		65	Jan 1960	8	297
Jul	5	70	Feb	8	305
Aug	6	76	Mar	8	313
Sep	6	82	Apr	8	321
Oct	6	88	May	8	329
Nov	7	95	Jun	8	337
Dec	7	102	Jul	8	345
			Aug	8	353
Jan 1958	7	109	Sep	8	361
Feb	7	116	Oct	8	369
Mar	7	123	Nov	8	377
Apr	7	130	Dec	8	385
May	7	137			
Jun	8	145	Jan 1961	8	393
Jul	8	153	Feb	8	401
Aug	8	161	Mar	8	409
Sep	8	169	Apr	8	417
Oct	8	177	May	8	425
Nov	8	185	Jun	8	433
Dec	8	193	Jul	8	441
			Aug	8	449
Jan 1959	8	201	Sep	8	457
Feb	8	209	Oct	8	465
Mar	8	217	Nov	8	473
Apr	8	225	Dec	8	481
May	8	233			
Jun	8	241	Jan 1962	8	489
Jul	8	249	Feb	8	497
Aug	8	257	Mar	8	505
Sep	8	265	Apr	8	513
Oct	8	273	May	8	521
Nov	8	281	Jun	8	529
Dec	8	289			

S-E-C-R-E-T

S-E-C-R-E-T

Table 7

Production of Bison at Plant No. 22

Two 46-hour Shifts per Week

			Units		
Months from Go Ahead	Monthly Production	Cumulative Production	Months from Go Ahead	Monthly Production	Cumulative Production
20	1	1	61	12	389
21	2	3	62	12	401
22	3	6	63	12	413
23	4	10	64	12	425
24 (1 July 59)	5	15	65	12	437
25	5	20	66	12	449
26	6	26	67	12	461
27	6	32	68	12	473
28	7	39	69	12	485
29	7	46	70	12	497
30	7	53	71	12	509
31	8	61	72	12	521
32	8	69	73	12	533
33	8	77	74	12	545
34	9	86	75	12	557
35	9	95	76	12	569
36 (1 July 60)	9	104	77	12	581
37	10	114	78	12	593
38	10	124	79	12	605
39	10	134	80	12	617
40	10	144	81	12	629
41	10	154	82	12	641
42	11	165	83	12	653
43	11	176	84	12	665
44	11	187	85	12	677
45	11	198	86	12	689
46	11	209	87	12	701
47	12	221	88	12	713
48	12	233	89	12	725
49	12	245	90	12	737
50	12	257			
51	12	269			
52	12	281			
53	12	293			
54	12	305			
55	12	317			
56	12	329			
57	12	341			
58	12	353			
59	12	365			
60	12	377			

S-E-C-R-E-T

Table 8

Production of Bison at Plant No. 1

Two 46-hour Shifts per Week

			Units		
Months from Go Ahead	Monthly Production	Cumulative Production	Months from Go Ahead	Monthly Production	Cumulative Production
20	1	1	60	7	219
21	1	2	61	7	226
22	2	4	62	7	233
23	3	7	63	7	240
24 (1 July 59)	3	10	64	7	247
25	3	13	65	7	254
26	3	16	66	7	261
27	3	19	67	7	268
28	4	23	68	7	275
29	4	27	69	7	282
30	4	31	70	7	289
31	4	35	71	7	296
32	5	40	72	7	303
33	5	45	73	7	310
34	5	50	74	7	317
35	5	55	75	7	324
36 (1 July 60)	5	60	76	7	331
37	5	65	77	7	338
38	6	71	78	7	345
39	6	77	79	7	352
40	6	83	80	7	359
41	6	89	81	7	366
42	6	95	82	7	373
43	6	101	83	7	380
44	6	107	84	7	387
45	7	114	85	7	394
46	7	121	86	7	401
47	7	128	87	7	408
48	7	135	88	7	415
49	7	142	89	7	422
50	7	149	90	7	429
51	7	156			
52	7	163			
53	7	170			
54	7	177			
55	7	184			
56	7	191			
57	7	198			
58	7	205			
59	7	212			

~~S-E-C-R-E-T~~

Table 9

Production of Bison at Plant No. 39 or Plant No 18

Two 46-hour Shifts per Week

			Units		
Months from Go Ahead	Monthly Production	Cumulative Production	Months from Go Ahead	Monthly Production	Cumulative Production
20	1	1	60	11	353
21	2	3	61	11	364
22	3	6	62	11	375
23	4	10	63	11	386
24	5	15	64	11	397
25	5	20	65	11	408
26	6	26	66	11	419
27	6	32	67	11	430
28	6	38	68	11	441
29	6	44	69	11	452
30	7	51	70	11	463
31	7	58	71	11	474
32	7	65	72	11	485
33	8	73	73	11	496
34	8	81	74	11	507
35	8	89	75	11	518
36	9	98	76	11	529
37	9	107	77	11	540
38	9	116	78	11	551
39	10	126	79	11	562
40	10	136	80	11	573
41	10	146	81	11	584
42	10	156	82	11	595
43	10	166	83	11	606
44	11	177	84	11	617
45	11	188	85	11	628
46	11	199	86	11	639
47	11	210	87	11	650
48	11	221	88	11	661
49	11	232	89	11	672
50	11	243	90	11	683
51	11	254			
52	11	265			
53	11	276			
54	11	287			
55	11	298			
56	11	309			
57	11	320			
58	11	331			
59	11	342			

~~S-E-C-R-E-T~~

S-E-C-R-E-T

Table 10

Production of Bison at Plant No. 64

Two 46-hour Shifts per Week

			Units		
Months from Go Ahead	Monthly Production	Cumulative Production	Months from Go Ahead	Monthly Production	Cumulative Production
20	1	1	59	3	83
21	1	2	60	3	86
22	1	3	61	3	89
23	1	4	62	3	92
24	1	5	63	3	95
25	1	6	64	3	98
26	1	7	65	3	101
27	1	8	66	3	104
28	1	9	67	3	107
29	1	10	68	3	110
30	2	12	69	3	113
31	2	14	70	3	116
32	2	16	71	3	119
33	2	18	72	3	122
34	2	20	73	3	125
35	2	22	74	3	128
36	2	24	75	3	131
37	2	26	76	3	134
38	2	28	77	3	137
39	2	30	78	3	140
40	2	32	79	3	143
41	2	34	80	3	146
42	2	36	81	3	149
43	2	38	82	3	152
44	2	40	83	3	155
45	2	42	84	3	158
46	2	44	85	3	161
47	3	47	86	3	164
48	3	50	87	3	167
49	3	53	88	3	170
50	3	56	89	3	173
51	3	59	90	3	176
52	3	62			
53	3	65			
54	3	68			
55	3	71			
56	3	74			
57	3	77			
58	3	80			

S-E-C-R-E-T

Table 11

Production of Bear at Plant No. 18

Two 46-hour Shifts per Week
Using Entire Plant
Acceleration Beginning 1 July 1957

			Units		
Month	Monthly Production	Cumulative Production	Month	Monthly Production	Cumulative Production
Jun 1957	2	51	Jan 1960	15	457
Jul	8	59	Feb	15	472
Aug	9	68	Mar	15	487
Sep	9	77	Apr	15	502
Oct	10	87	May	15	517
Nov	10	97	Jun	15	532
Dec	11	108	Jul	15	547
Jan 1958	11	119	Aug	15	562
Feb	11	130	Sep	15	577
Mar	12	142	Oct	15	592
Apr	12	154	Nov	15	607
May	12	166	Dec	15	622
Jun	13	179	Jan 1961	15	637
Jul	13	192	Feb	15	652
Aug	13	205	Mar	15	667
Sep	14	219	Apr	15	682
Oct	14	233	May	15	697
Nov	14	247	Jun	15	712
Dec	15	262	Jul	15	727
Jan 1959	15	277	Aug	15	742
Feb	15	292	Sep	15	757
Mar	15	307	Oct	15	772
Apr	15	322	Nov	15	787
May	15	337	Dec	15	802
Jun	15	352	Jan 1962	15	817
Jul	15	367	Feb	15	832
Aug	15	382	Mar	15	847
Sep	15	397	Apr	15	862
Oct	15	412	May	15	877
Nov	15	427	Jun	15	892
Dec	15	442			

S-E-C-R-E-T

Table 12

Production of Bear at Plant No. 1.

Two 46-hour Shifts per Week
Acceleration Beginning 1 July 1957

			Units		
Months from Go Ahead	Monthly Production	Cumulative Production	Months from Go Ahead	Monthly Production	Cumulative Production
19	1	1	57	10	278
20	2	3	58	10	288
21	3	6	59	10	298
22	3	9	60	10	308
23	4	13	61	10	318
24	4	17	62	10	328
25	4	21	63	10	338
26	4	25	64	10	348
27	5	30	65	10	358
28	5	35	66	10	368
29	6	41	67	10	378
30	6	47	68	10	388
31	6	53	69	10	398
32	6	59	70	10	408
33	6	65	71	10	518
34	7	72	72	10	628
35	7	79			
36	7	86			
37	7	93			
38	8	101			
39	8	109			
40	8	117			
41	8	125			
42	8	133			
43	9	142			
44	9	151			
45	9	160			
46	9	169			
47	9	178			
48	10	188			
49	10	198			
50	10	208			
51	10	218			
52	10	228			
53	10	238			
54	10	248			
55	10	258			
56	10	268			

S-E-C-R-E-T

S-E-C-R-E-T

Table 13

Production of Bear at Plant No. 22

Two 40-hour Shifts per Week

			Units		
Months from Go Ahead	Monthly Rate	Cumulative Production	Months from Go Ahead	Monthly Rate	Cumulative Production
19	1	1	57	15	452
20	2	3	58	15	467
21	3	6	59	15	482
22	4	10	60	15	497
23	5	15	61	15	512
24	662	21	15	15	527
25	7	28	63	15	542
26	8	36	64	15	557
27	8	44	65	15	572
28	9	53	66	15	587
29	9	62	67	15	602
30	10	72	68	15	617
31	10	82	69	15	632
32	11	93	70	15	647
33	11	104	71	15	662
34	12	116	72	15	677
35	12	128			
36	13	141			
37	13	154			
38	14	168			
39	14	182			
40	15	197			
41	15	212			
42	15	227			
43	15	242			
44	15	257			
45	15	272			
46	15	287			
47	15	302			
48	15	317			
49	15	332			
50	15	347			
51	15	362			
52	15	377			
53	15	392			
54	15	407			
55	15	422			
56	15	437			

S-E-C-R-E-T

S-E-C-R-E-T

Table 14

Production of Bear at Plant No. 39

Two 46-hour Shifts per Week

			Units		
Months from Go Ahead	Monthly Rate	Cumulative Production	Months from Go Ahead	Monthly Rate	Cumulative Production
19	1	1	57	15	424
20	2	3	58	15	439
21	3	6	59	15	454
22	4	10	60	15	469
23	5	15	61	15	484
24	5	20	62	15	499
25	6	26	63	15	514
26	7	33	64	15	529
27	8	41	65	15	544
28	8	49	66	15	559
29	8	57	67	15	574
30	9	66	68	15	589
31	9	75	69	15	604
32	10	85	70	15	619
33	10	95	71	15	634
34	10	105	72	15	649
35	11	116			
36	11	127			
37	12	139			
38	12	151			
39	12	163			
40	13	176			
41	13	189			
42	13	202			
43	14	216			
44	14	230			
45	14	244			
46	15	259			
47	15	274			
48	15	289			
49	15	304			
50	15	319			
51	15	334			
52	15	349			
53	15	364			
54	15	379			
55	15	394			
56	15	409			

S-E-C-R-E-T

S-E-C-R-E-T

Table 15

Production of Bear at Plant No. G4

Two 40-hour Shifts per Week

			Units		
Months from Go Ahead	Monthly Rate	Cumulative Production	Months from Go Ahead	Monthly Rate	Cumulative Production
19	1	1	57	3	89
20	1	2	58	4	93
21	1	3	59	4	97
22	1	4	60	4	101
23	1	5	61	4	105
24	1	6	62	4	109
25	1	7	63	4	113
26	2	9	64	4	117
27	2	11	65	4	121
28	2	13	66	4	125
29	2	15	67	4	129
30	2	17	68	4	133
31	2	19	69	4	137
32	2	21	70	4	141
33	2	23	71	4	145
34	2	25	72	4	149
35	2	27			
36	2	29			
37	2	31			
38	2	33			
39	2	35			
40	3	38			
41	3	41			
42	3	44			
43	3	47			
44	3	50			
45	3	53			
46	3	56			
47	3	59			
48	3	62			
49	3	65			
50	3	68			
51	3	71			
52	3	74			
53	3	77			
54	3	80			
55	3	83			
56	3	86			